



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4471-041
Job Sheet 188721



Part No: D4471-041

Job Qty: 2 pcs

Part Name: Mid Rib Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/14/19

Job Tracking No:

Due Date: 1/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:B MAKE PART IN HOUSE (USED TO BE OUTSOURCED) RQ 19.01.14 VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	CNC Vertical Machining	2 pcs		1/31/19	0.00	3.00	HAAS - 1 - B4B		19-03-15
120	QC 2	2 pcs		1/31/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		19-03-15
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S163171



Part: D4471-041

Job No: 188721

Serial No/Batch: S163171

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/15/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

125 QC 8	2 pcs	1/31/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	D.R. 19/03/16
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
130 Handfinish - 1-1 Chemical-B4B	2 pcs	1/31/19	0.00 0.13	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R. 19/03/18
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
131 QC 7	2 pcs	1/31/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Other/Details:					

				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 38	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
180	Spray Paint - 2 - B4B	2 pcs	1/31/19	0.00 0.00	Spray Paint - 1 - B4B
					Spray Paint - 2 - B4B
					Spray Paint - 3 - B4B
					Spray Paint - 4 - B4B
190	QC 14	2 pcs	1/31/19	0.00 0.00	QC 14 - 15
					QC 14 - 2
					QC 14 - 34
					QC 14 - 38
					QC 14 - 41
					QC 14 - 51
					QC 14 - 58
					QC 14 - 59
					QC 14 - 9
					QC 14 - 68
191	Small Fab - 2 - B4B	2 pcs	1/31/19	0.00 0.87	Small Fab - 1 - B4B
					Small Fab - 2 - B4B
					Small Fab - 3 - B4B
					Small Fab - 4 - B4B
					Small Fab - 5 - B4B
					Small Fab - 6 - B4B
					Small Fab - 7 - B4B
192	QC 5	2 pcs	1/31/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 38
					QC 5 - 42
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30

Handwritten signature

RD 19-3-19

MAR 19 2019
DAS
40
9-89

DAS
36
9-89

MAR 20 2019
DAS
40
9-89

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Other/Details:					

200 Packaging 3-1 - Stock - B4B	2	1/31/19	0.00 0.00	Packaging 3 - 1 - B4B
	pcs			Packaging 3 - 2 - B4B
				Packaging 3 - 3 - B4B
				Packaging 3 - 4 - B4B
				Packaging 3 - 5 - B4B
				Packaging 3 - 6 - B4B
				Packaging 3 - 7 - B4B
				Packaging 3 - 8 - B4B
				Packaging 3 - 9 - B4B
				Packaging 3 - 10 - B4B
				Packaging 3 - 11 - B4B
				Packaging 3 - 12 - B4B
				Packaging 3 - 13 - B4B
				Packaging 3 - 14 - B4B
				Packaging 3 - 15 - B4B
				Packaging 3 - 16 - B4B
				Packaging 3 - 17 - B4B
				Packaging 3 - 18 - B4B
				Packaging 3 - 19 - B4B
				Packaging 3 - 20 - B4B
				Packaging 3 - 21 - B4B
				Packaging 3 - 22 - B4B
				Packaging 3 - 23 - B4B
				Packaging 3 - 24 - B4B
				Packaging 3 - 25 - B4B
				Packaging 3 - 26 - B4B
				Packaging 3 - 27 - B4B
				Packaging 3 - 28 - B4B
				Packaging 3 - 29 - B4B
				Packaging 3 - 30 - B4B
				Packaging 3 - 31 - B4B
				Packaging 3 - 32 - B4B
				Packaging 3 - 33 - B4B
				Packaging 3 - 34 - B4B
				Packaging 3 - 35 - B4B

Stanza SA MAR 21 2019

210 QC 21 - SA	2	1/31/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9-00
	pcs				MAR 21 2019

Part Op 110 - -Cut blanks at 16.25" -Machine as per folio FB572 and drawing D4471 -Deburr.

Descriptions: 130 - Chemical Conversion Coat per QSI005 4.1

131 - QC7-Inspect Chemical Conversion Coat

180 - Spray Paint / NDT Room - PRIME AS PER DWG TEMPO GREY BATCH: 5135773

190 - QC14- Inspect Spray Paint

191 - Small Fab - INSTALL NUT PLATES AS PER DWG

192 - QC5- Inspect part completeness to step on W/O

200 - Identify as per dwg & Stock Location: _____

210 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X04.000	6061-T6 Bar 1.00 X 4.00	2.8400 ft (1.42 ea)	110-CNC Vertical Machining	5149553
MS20605-AD3W4	Blind Rivet	8 Ea (4 ea)	191-Small Fab - 2 - B4B	
MS21069L08	Anchor Nut	4 Ea (2 ea)	191-Small Fab - 2 - B4B	F123522-40

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-CNC Vertical Machining	M6061T6B1.000X04.000	3	46	0
191-Small Fab - 2 - B4B	MS20605-AD3W4	8	60	0
	MS21069L08	4	376	0

Part Specifications

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Eng. (Non-AW) ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Water Jet ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Supplier Quality ☐</td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐																																
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Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____																																													
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Other/Details: _____																																																	

Specifications could not be found.

Plex 1/14/19 3:15 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



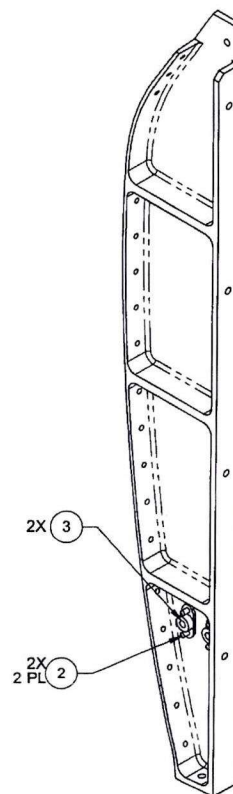
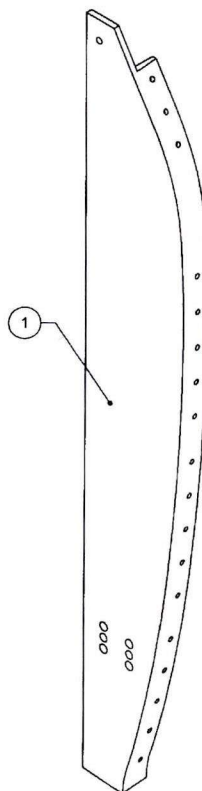
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Description Work Order Deviation		Disposition		Completed By	
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Other/Details:					

ITEM	QTY	P/N	DESCRIPTION
	X	D4471-041	MID RIB ASSY (LH)
1	1	D4471-1	MID RIB (LH)
2	4	MS20605AD3W4	CSK BLIND RIVET
3	2	MS21069L08	NUTPLATE



D4471-041 MID RIB ASSY (LH)

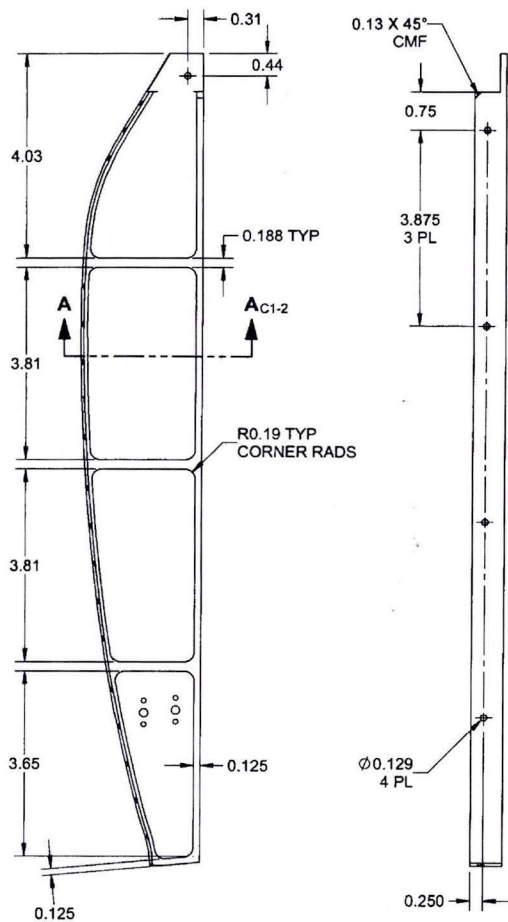
NOTES:

- 1) MATERIAL -1: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
(PRIOR TO HARDWARE INSTALLATION)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.60 lbs
- 8) ALL NON DIMENSIONED FEATURES PER CAD FILE "D4471-1-REV.B.STP"
- 9) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART
(NOT NECESSARY TO FACE MATERIAL).

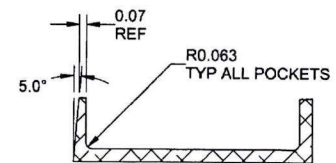
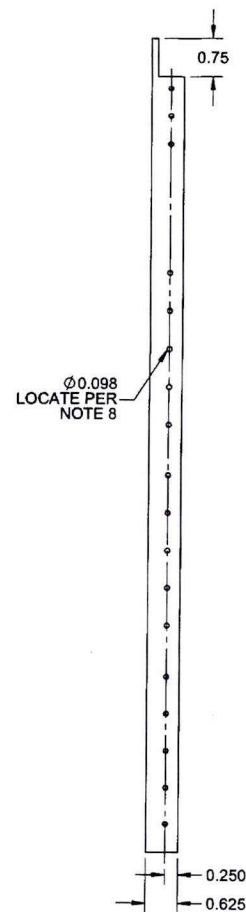
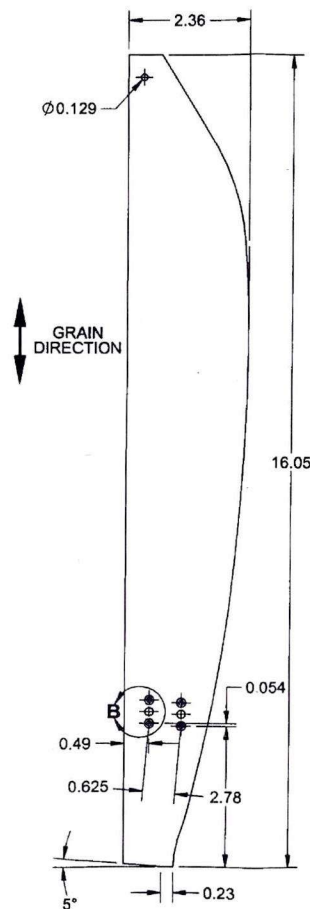
B	ADDED -042 & -2 (RH CONFIGURATION), PRIMER NOTE ADDED. NUTPLATE RIVET WAS MS20426AD3-4.	AJS	12.09.10
A	NEW ISSUE	AJS	12.03.05
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	21	D4471	SHEET 1 OF 4
APPROVED	14	TITLE	SCALE
DE APPR.	14	MID RIB ASSEMBLY	NTS
DATE	12.09.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

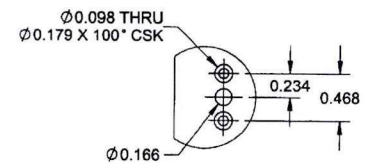
D
C
B
A



D4471-1 MID RIB (LH)



**SECTION A-A C7-2
(SCALE 2X)**



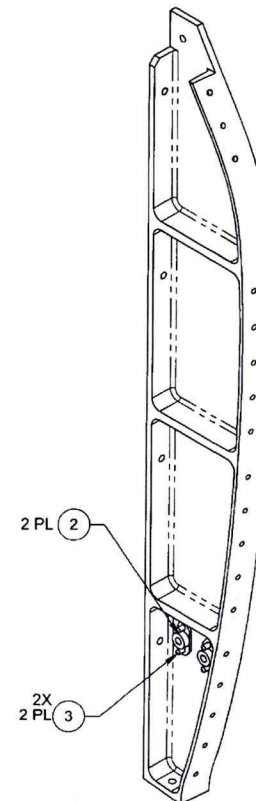
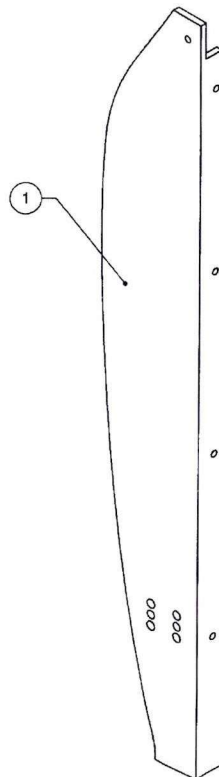
**DETAIL B 85-2
NUTPLATE HOLE DETAIL 2 PL
(SCALE 2X)**

RELEASED
2012-09-27

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	2/	D4471	SHEET 2 OF 4
APPROVED	1/	TITLE	SCALE
DE APPR.	1/	MID RIB ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

ITEM	QTY -042	P/N	DESCRIPTION
	X	D4471-042	MID RIB ASSY (RH)
1	1	D4471-2	MID RIB (RH)
2	2	MS21069L08	NUTPLATE
3	4	MS20605AD3W4	CSK BLIND RIVET

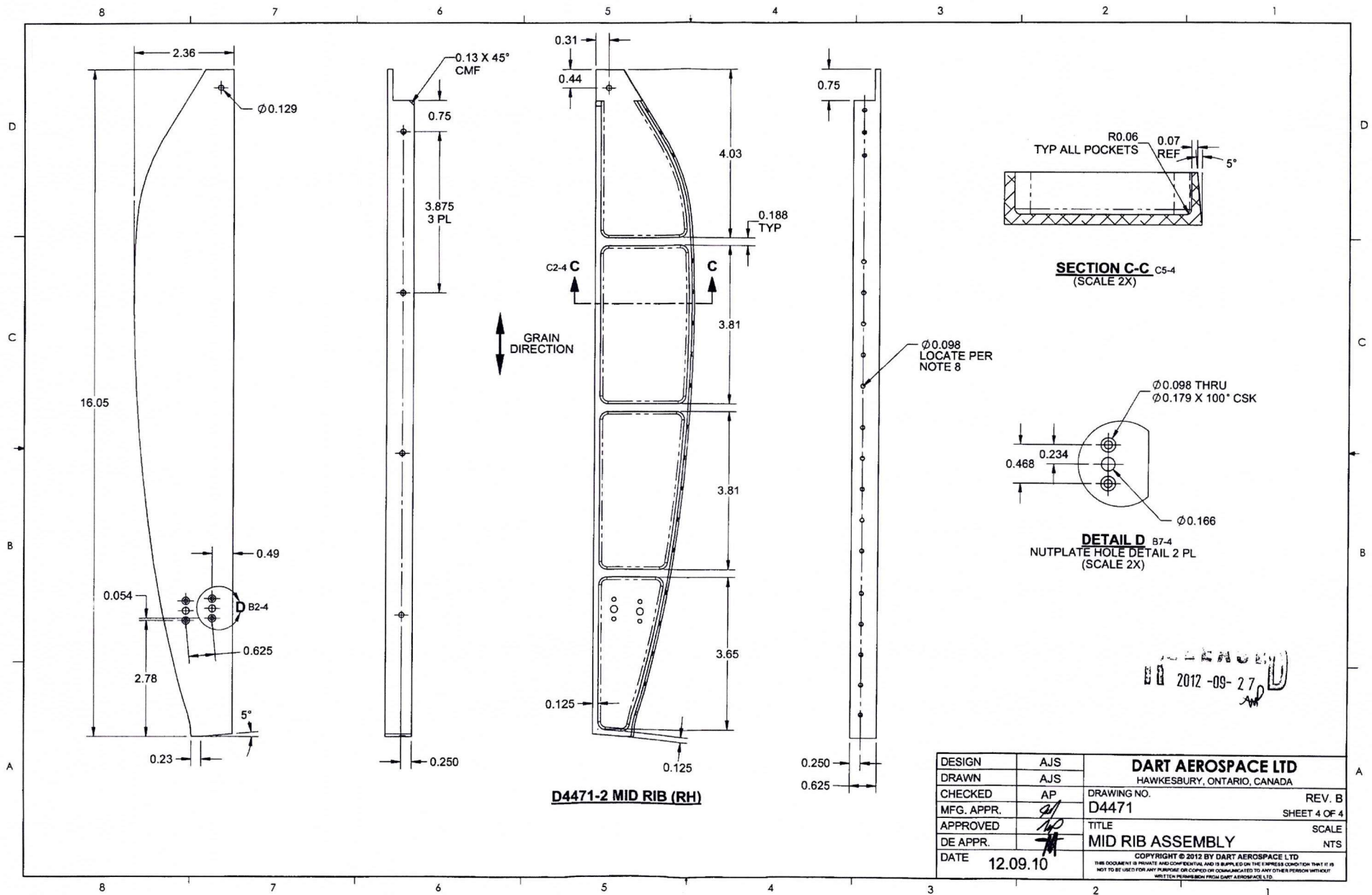


D4471-042 MID RIB ASSY (RH)

NOTES:

- 1) MATERIAL -2: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
(PRIOR TO HARDWARE INSTALLATION)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.60 lbs
- 8) ALL NON DIMENSIONED FEATURES PER CAD FILE "D4471-2-REVB.STP"
- 9) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART
(NOT NECESSARY TO FACE MATERIAL).

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO. D4471	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE MID RIB ASSEMBLY	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	SCALE NTS	
DE APPR.	<i>[Signature]</i>		
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DART AEROSPACE LTD		Work Order: 188 721
Description: Mid Rib Assembly, LH		Part Number: D4471-1
Inspection Dwg: D4471 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.03	+/- .030	4.030	✓		5210	Vern
3.81	+/- .030	3.810	✓			
3.81	+/- .030	3.810	✓			
3.65	+/- .030	3.650	✓			
.125	+/- .010	.125	✓			
.125	+/- .010	.125	✓			
R.19	+/- .030	.188	✓		Red gauge	
.188	+/- .010	.185	✓			
.44	+/- .030	.435	✓			
.31	+/- .030	.307	✓			
13 V45°	+/- .03 X .5°	.130	✓			
.75	+/- .030	.747	✓			
3.875	+/- .005	3.875	✓			
φ.129	+ .005 / - .001	.129	✓			
.250	+/- .010	.248	✓			
2.360	+/- .010	2.361	✓			
φ.129	+ .005 / - .001	.129	✓			
.49	+/- .030	.484	✓			
.625	+/- .005	.626	✓			
5°	+/- .5°	5°	✓		Protractor	
.23	+/- .030	.230	✓			
2.78	+/- .030	2.778	✓		Height gauge	
.054	+/- .010	.055	✓		"	
16.05	+/- .030	16.047	✓		"	
.75	+/- .030	.750	✓			
φ.098	+ .004 / - .001	.098	✓			
.250	+/- .010	.245	✓			
.625	+/- .010	.628	✓			
5°	+/- .5°	5°	✓		Protractor	
.468	+/- .005	.468	✓			
.234	+/- .005	.237	✓			
φ.166	+ .005 / - .001	.166	✓			

Measured by: 20	Checked by: [Signature]	QC Inspector:
Date: 19-03-15	Date: 19/03/16	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	